

Work Order ID 56499

February 25, 2010 10:54:19 AM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 2/25/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: *10-2-25*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: *AA* & Dwg D3391 Rev: *H*

scribe batch # on fwd end at 90 degree

aim 10-3-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AWY/MB 10-03-04

111

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SA 10/03/10

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: _____ & Dwg D3391 Rev: _____ 2-Deburr	0.00 0.00	1ml 10/03/09			①	①		
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	1ml 10/03/09			①	①		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SA 10/03/10			1	①		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

Y 1013116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 3/05/10

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8.063/17

76

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

DP

10-3-17

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

1 4/10/17

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 3/05/10

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



Skidtubes

Skidtubes

Skidtubes

Memo

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: 112417

exp. date: 10/2/30

cure time 12hrs as per QSI0015

0.00

0.00

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

- Pressure Wash

- Realdine as per PAR09043 = 7 m.k 10/05/05 (1X)

0.00

0.00

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

1114207

Memo

START TIME: 1:45pm

OVEN TEMPERATURE: 320°

FINISH TIME: 2:15pm

0.00

0.00

DP 10-3-17

8 10/03/18

(X)

10/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7 m. h 10/05/06 (1X)

260

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D3391
2-Install Aft Cap as per Dwg D3391
A/R Sikaflex-241/-291
Sikaflex expiry date: 10/08

M112429 = 7 m. h 10/05/06 (1X)

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/05/10

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 56499

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Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

Identify as per dwg & Stock Location:

B58380

0.00



Packaging

Memo

0.00

MF 10/05/06



Packaging

290

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10

MF 10-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

February 25, 2010 10:54:23 AM

Page 1

Work Order ID: 56499

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM ☐ ☐ ☐
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Date: 2/25/10

Required Date: 3/05/10

Start Qty: 1.00

Required Qty: 1.00

D6014-090

Manufactured No

100

Each

11.0000

1.0000



ALUMINUM EXTRUSION

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

-) - LG

42768

11

11

D3670-4-200

Manufactured No

230

Each

83.0000

4.0000



SPACER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48198

48269

83

4

79

AWM 10-3-2

DP 10-3-17

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

February 25, 2010 10:54:23 AM

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Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

52.0000

1.0000



Aft Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

29

52663

29

Main Warehouse

fp7

13

52663

13

Main Warehouse

ST

10

46327

4

48109

6

D3537-1

Manufactured No

270

Each

140.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

74

48288

2

55465

72

Main Warehouse

FP17

66

51678

1

51679

65

February 25, 2010 10:54:23 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

February 25, 2010 10:54:23 AM

Work Order ID: 56499



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/25/10

Required Date: 3/05/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM □□ □□
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3537-7 Manufactured No 270 Each 14.0000 1.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B 56831

ST

14

45408

3

46346

11

1x m.d
10/05/06

D3553-1 Manufactured No 270 Each 9.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

9

33868 ✓

9

1x m.d 10/05/06

D3553-3 Manufactured No 270 Each 58.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

58

53480 ✓

58

1x m.d 10/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 270 Each 1,682.000 2.0000



Phenolic Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1182	
39275	19	
42329	5	
47628	158	
52505	1000	
Main Warehouse		
ST117	500	
51674 ✓	500	

ALS4-1032-130 Purchased No 260 Each 1,678.000 14.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1678	
110511	1678	

M 114407

10/05/06
 2x m-l
 14x m-l
 10/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

270

Each

6,230.000 12.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6230

107441

16

110768

6214

270

Each

1,033.000 6.0000

AN3C4A

Purchased

No



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1033

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113644

394

113749

200

10/05/06

M-L

12 X

6x M-L 10/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

465.0000 4.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

111424

111707

112314

113121

113149

465

8

69

1

125

262

M114330

4x m-l
w/05/06

AN960C10L

Purchased

No

270

Each

388.0000 10.0000



washer

NAS1149C0332R

M114341

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

103585

Main Warehouse

ST

112116

112612

100

100

288

128

160

10x m-l
w/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50499
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓			
3.500	+/-0.010	3.499	✓			
88.93	+/-0.030	88.940	✓			
44.995	+/-0.030	44.990	✓			
Ø3.200	+/-0.010	3.197	✓			
88.93	+/-0.030	88.940	✓			
Ø3.750	+/-0.010	3.750	✓			
30° x 160° chamfer	+/-0.010	30° x 160°	✓			

Measured by: ANM/mb	Date: 10-3-4
Audited by: SK 10/10/10	Date:

HAAS Section						
1.526	+0.000/-0.030	1.526	✓			
7.500	+/-0.010	7.502	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.290	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.572	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	R.063	✓			
Ø0.484	+0.005/-0.001	Ø.489	✓			

Measured by: ANK	Date: 10/10/09
Audited by: SK 10/10/10	Date:

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	

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ENGINEERING

UNCONTROLLED COPY

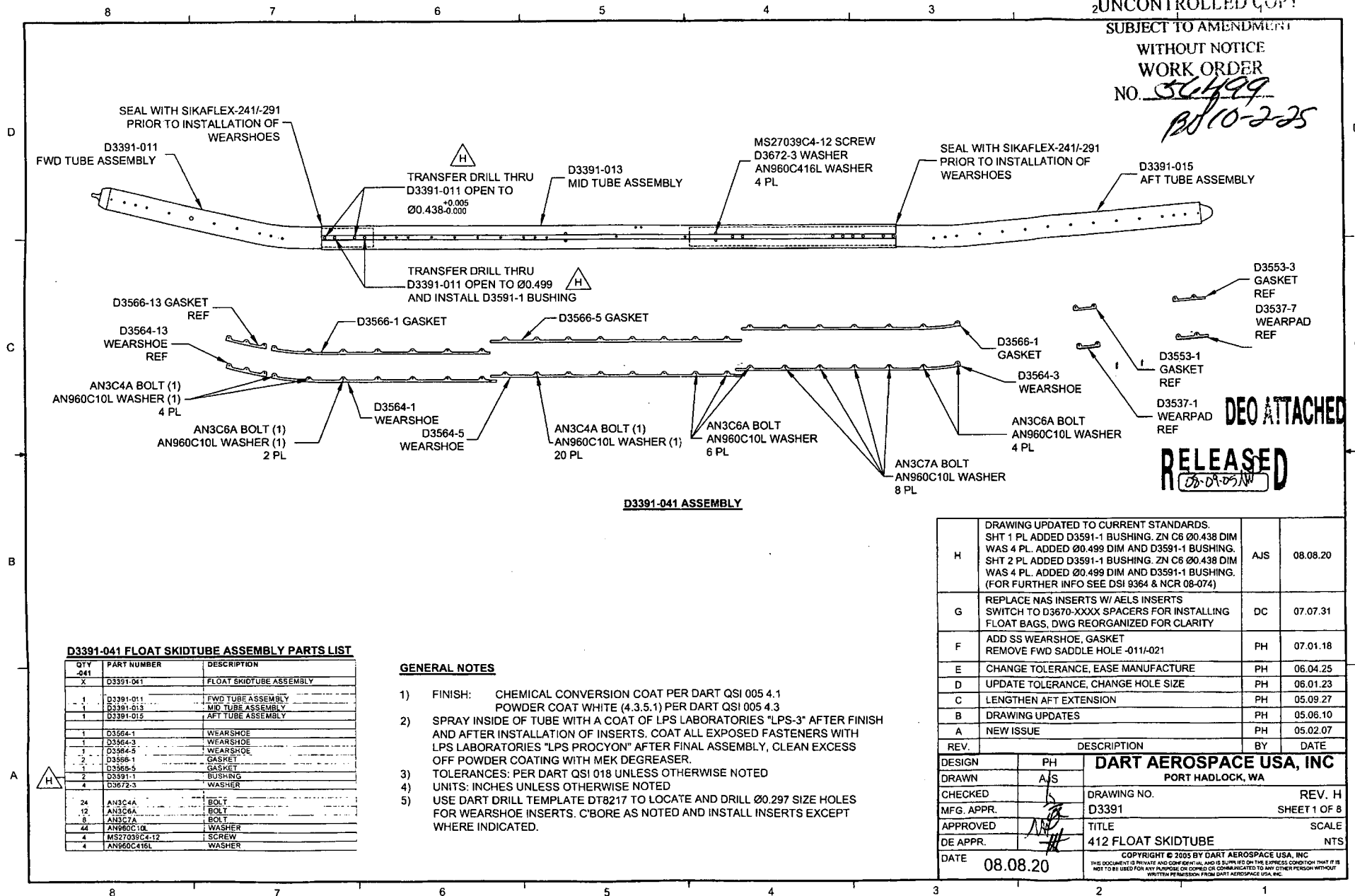
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

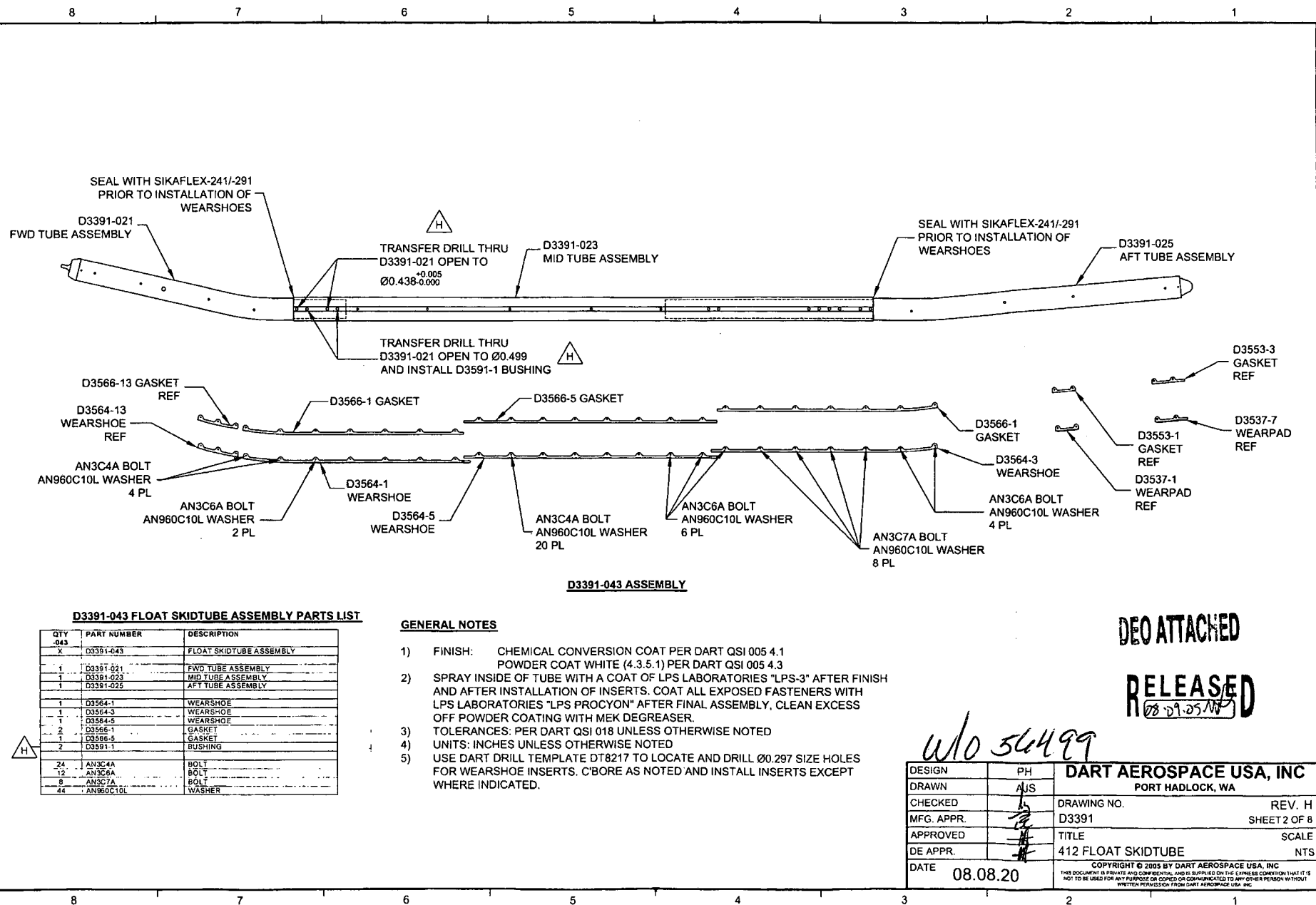
NO. 36499

2010-225



DEO ATTACHED

RELEASED
08-08-20



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

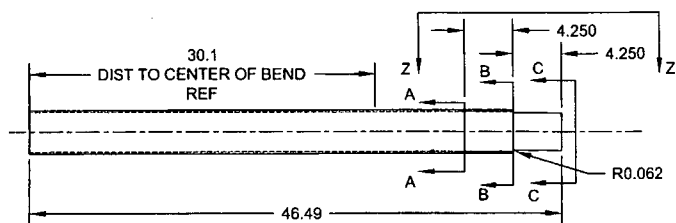
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

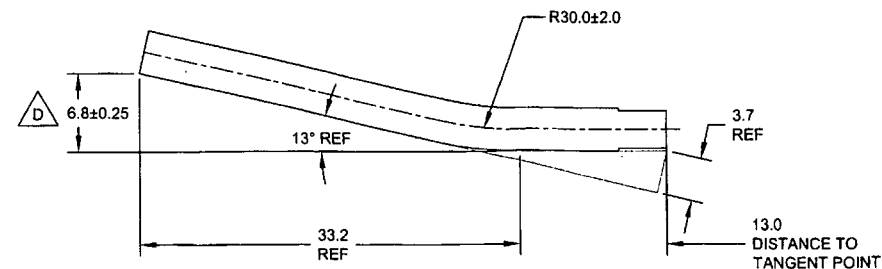
RELEASED
08-01-25-10

W/O 56499

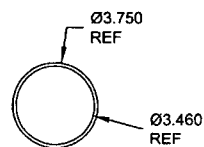
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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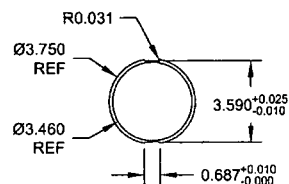
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



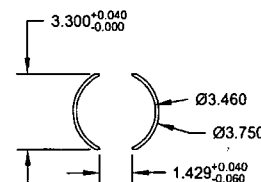
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



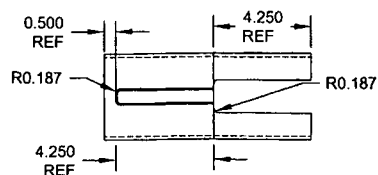
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



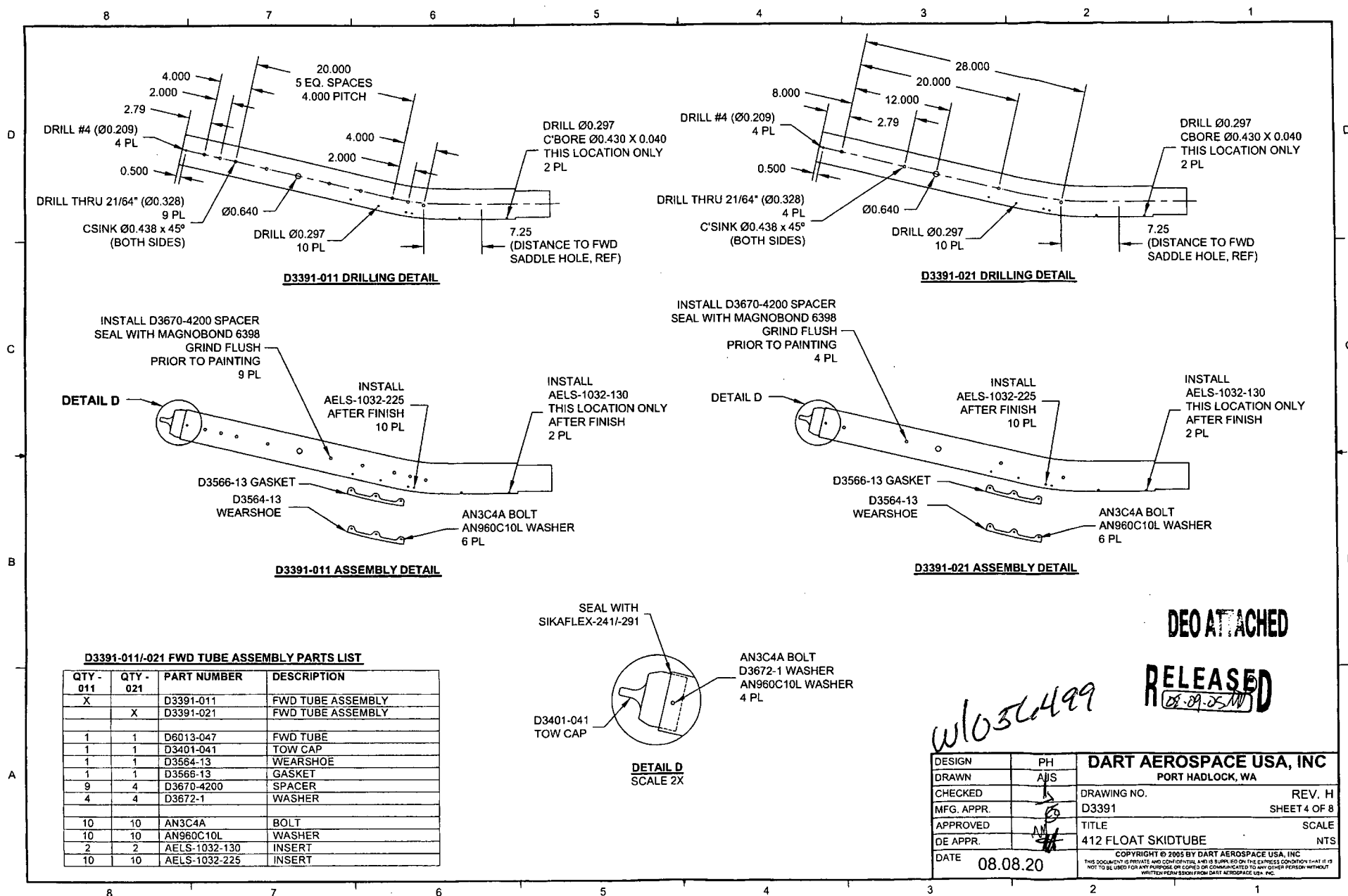
SECTION C-C
SCALE 2X

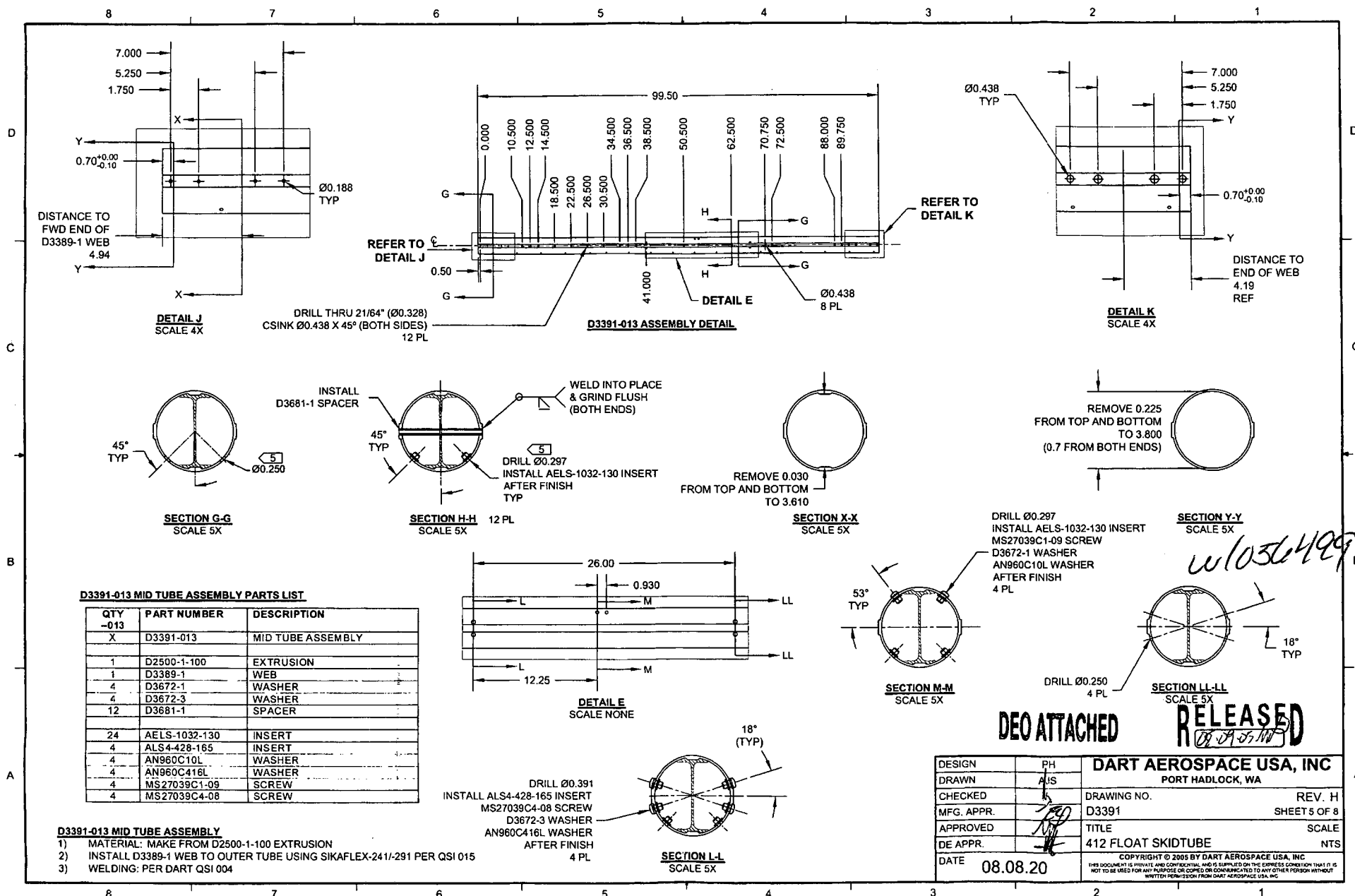


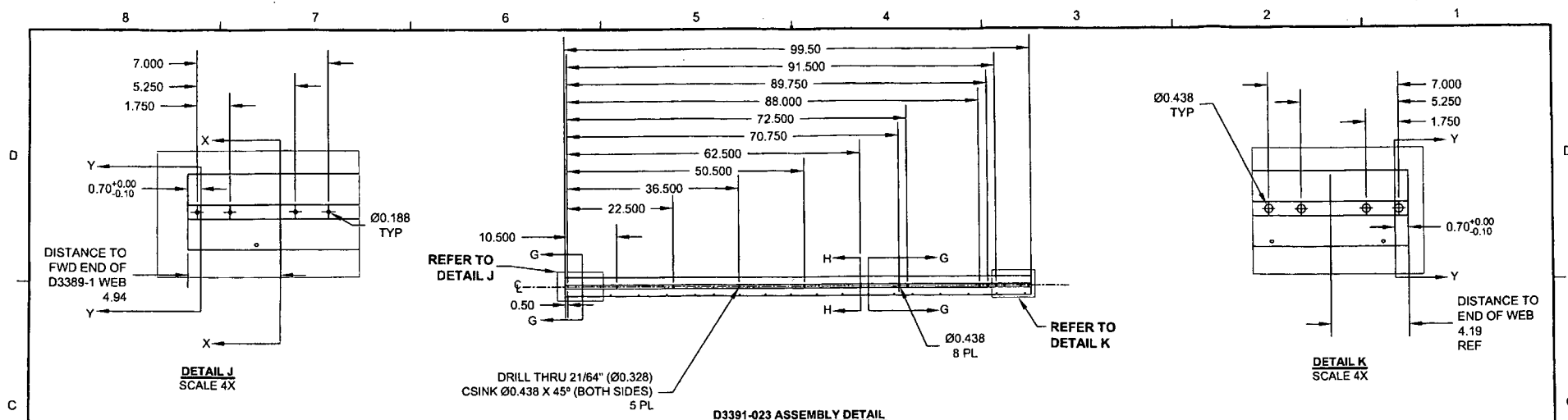
VIEW Z-Z
SCALE 2X

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28-05-11

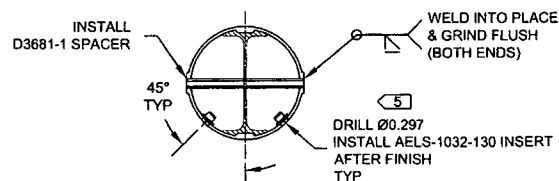
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MFG. APPR.		D3391	SHEET 3 OF 8
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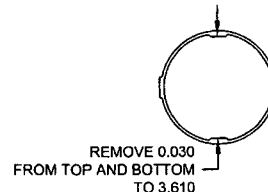




SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

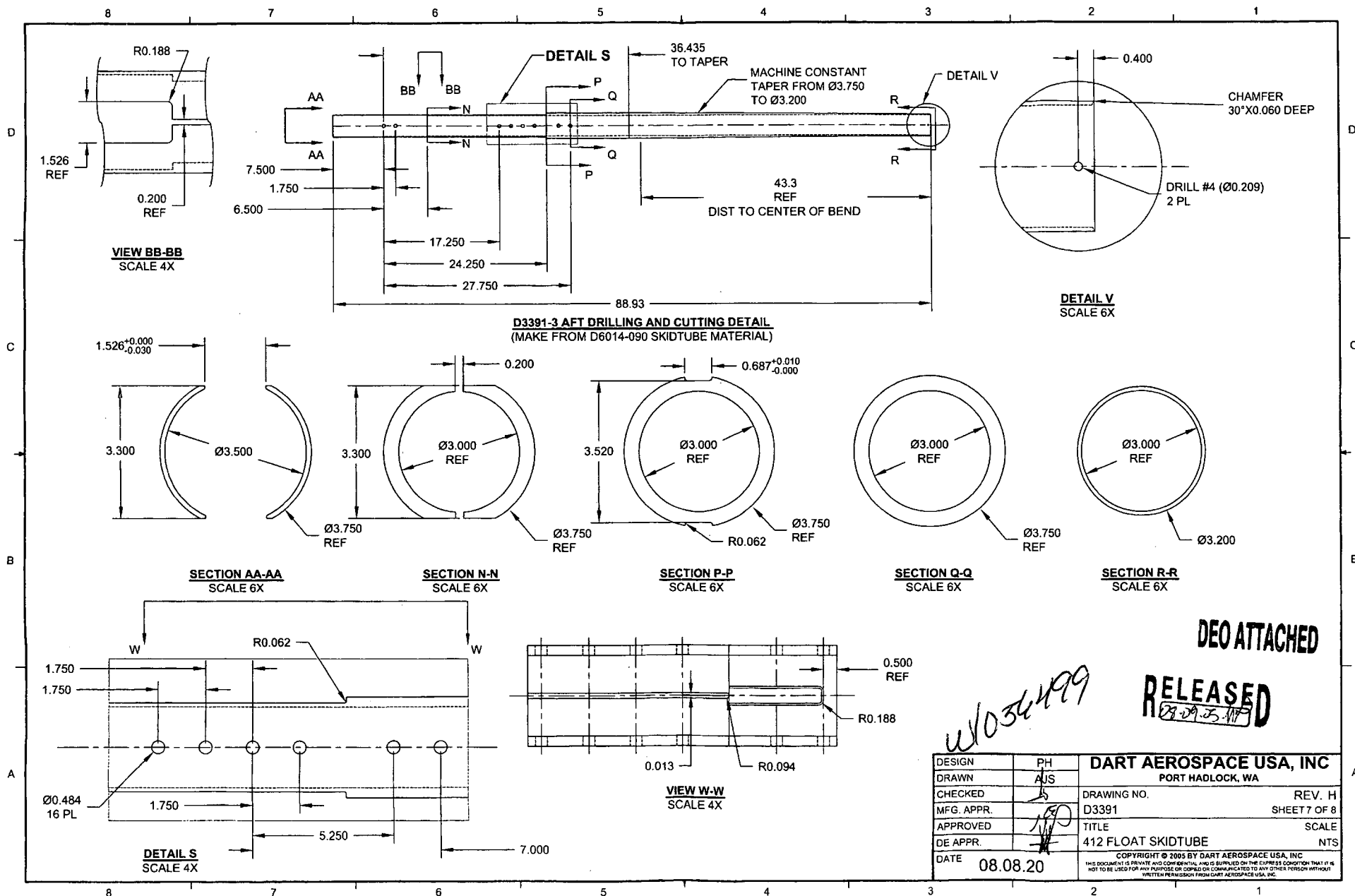
D3391-023 MID TUBE ASSEMBLY

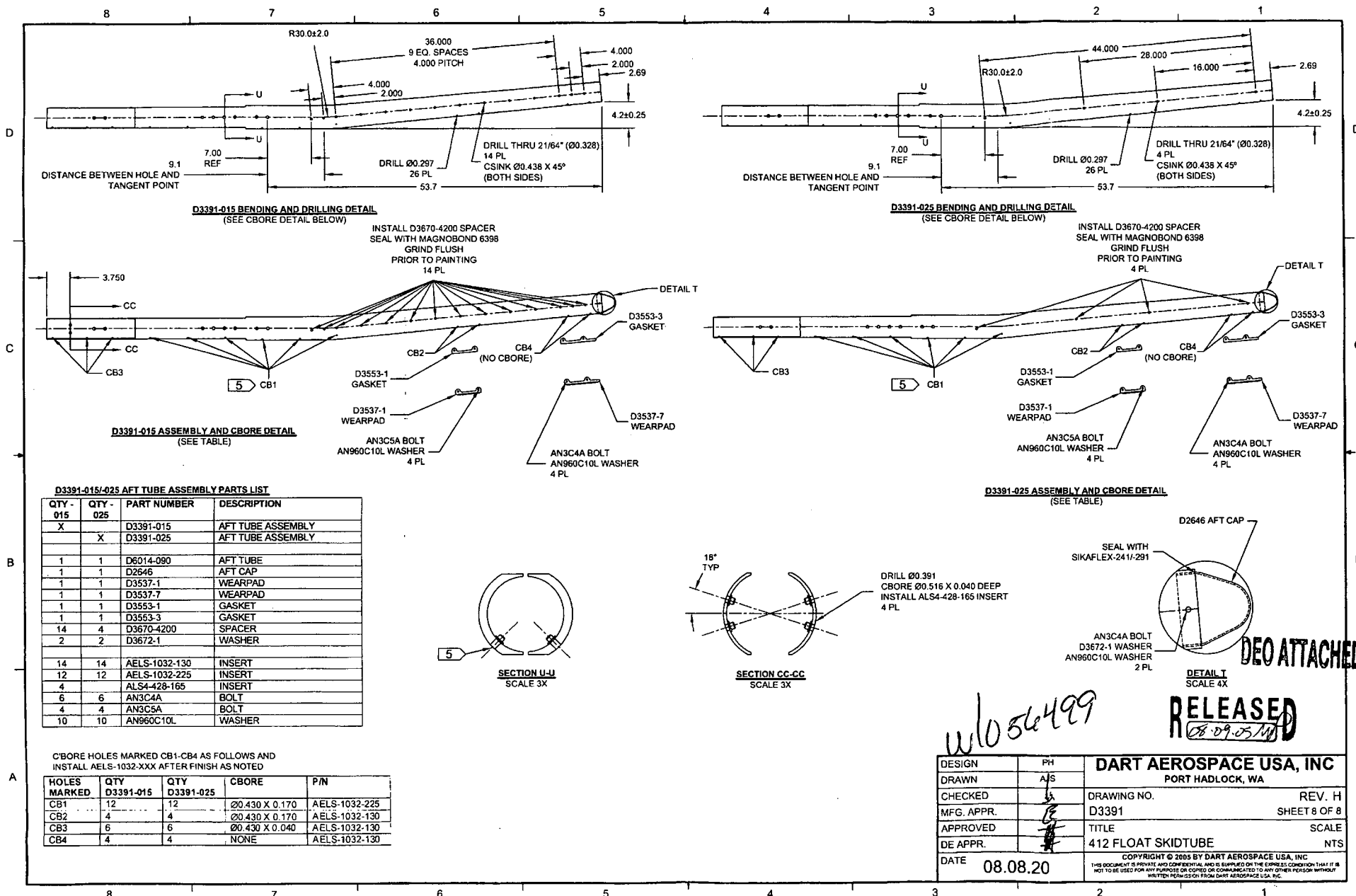
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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RELEASED
08-08-20





DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

W/O 36499

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